APPLICATION GUIDE

FLAKES PAINT ADDITIVE

How to Apply (Application Steps)

1 If your piece is already painted with a base coat, you can proceed to step #15.
2 Make sure you have good conditions for spraying. The best temperature for spraying this paint is 70-80 degrees F, and humidity of no greater than 50%.
3 Always apply paints in a well-ventilated area, and wear a NIOSH approved respirator to avoid breathing any fumes.
4 If your piece is already base coated, you can proceed to step #14.
5 Prepare and prime your part first. Epoxy primers are best for bare metal, and primer surfacers are best for plastics, fiberglass, or wood. Some plastics may require an adhesion promoter but most plastics, like ABS plastic, are fine without adhesion promoters.
6 Before applying your primer, remove all dirt, grease, oil, salt, and chemical contaminants, by washing the surface with a commercial detergent, or other suitable cleaning method.
7 Rinse with fresh water and allow to completely dry.
8 Remove any existing loose paint, or rust, etc., with a wire brush or sand paper.
9 Lightly sand glossy surfaces to create a surface profile for adhesion.
10 Apply your primer to the surface according to the manufacturer's specifications for your particular primer.
11 Let your primer cure according to the manufacturer's specifications for your particular primer.
12 Lightly scuff your primer with 800-1000 grit sand paper, or you can also use a red scotch-brite pad, to create a surface profile for adhesion.
13 Apply your base coat color over the primer according to the manufacturer's specifications for your particular base coat, using steady even passes, until you achieve coverage.
14 Let your base coat flash for 10-15 minutes, and then you are ready to apply the Flakes.
15 If your piece is already base coated **and cured**, then lightly scuff your base coat with 800-1000 grit sand paper, or a red scotch-brite pad to create a surface profile for adhesion.

16 Mix your Flakes into your clear carrier. These flakes are added completely to taste, and there is no set mixing ratio. Additionally, ALSA flakes come in many sizes. The larger flakes will require a “Flake Gun” to deposit them correctly, and should not be mixed into a carrier, but sprayed dry, using the before mentioned Flake Gun. For example the “Flake Buster” gun is a very well-known flake gun, and is perfect for the larger flakes. Smaller flakes can usually go through standard paint guns, although you will want to use a large tip size for those. Tip size 1.3 and up is common for the smaller flakes.
17 Begin applying this over your base coat, in wet coats. Check the appearance after each coat, to determine the effect. If a stronger effect is desired, then additional coats can be applied, allowing 10-15 minutes between each coat. Check the appearance between each coat.
18 Keep shaking or stirring the flakes, as they will settle in your paint gun, if not kept moving.
19 One the desired effect is achieved, let that last coat dry for an additional 10-15 minutes, and then apply 1-2 FINAL coats, of **just clear coat**, such as Alsa’s “Speed Clear”, to add depth, and an additional layer of protection.
20 Extra coats of clear may be required, especially for the larger flakes, to achieve a smooth finish.